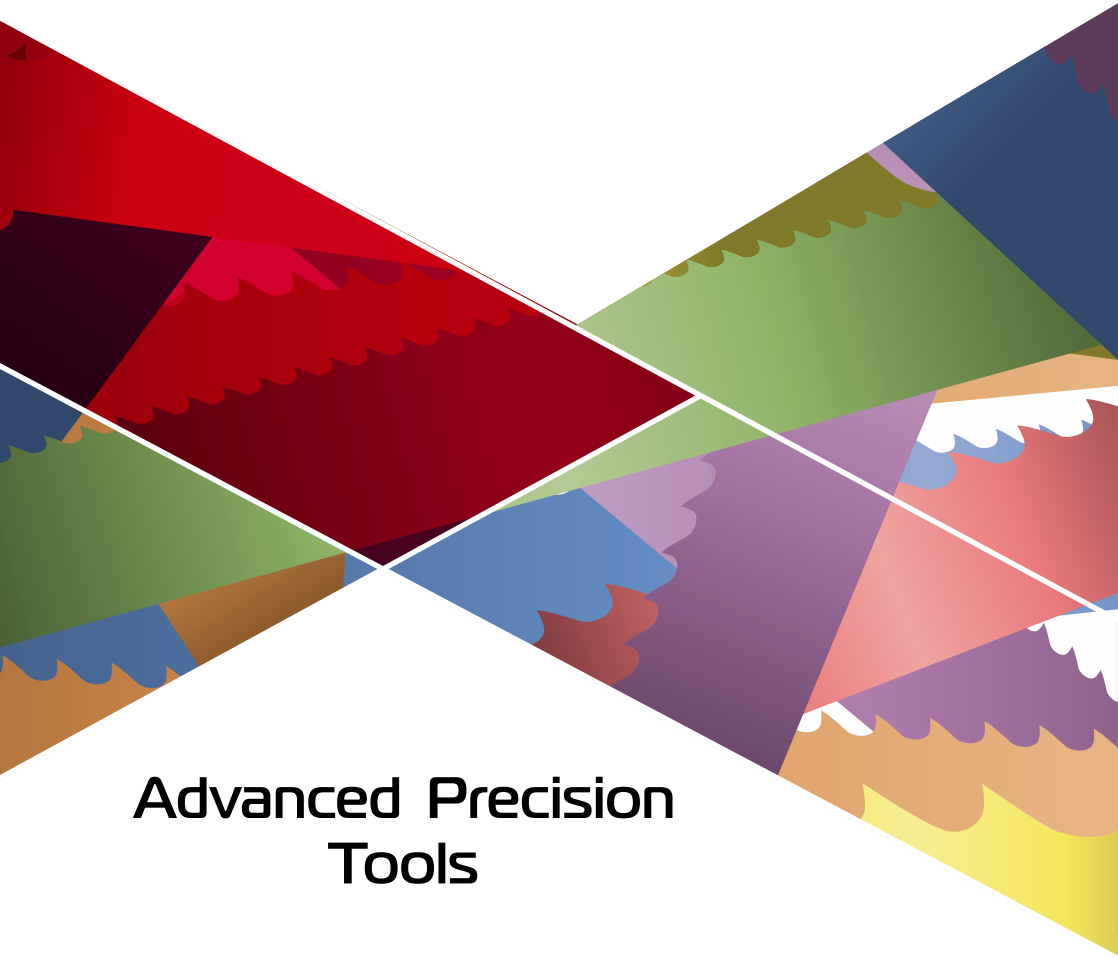




Metal Band Saw Blades



Advanced Precision
Tools

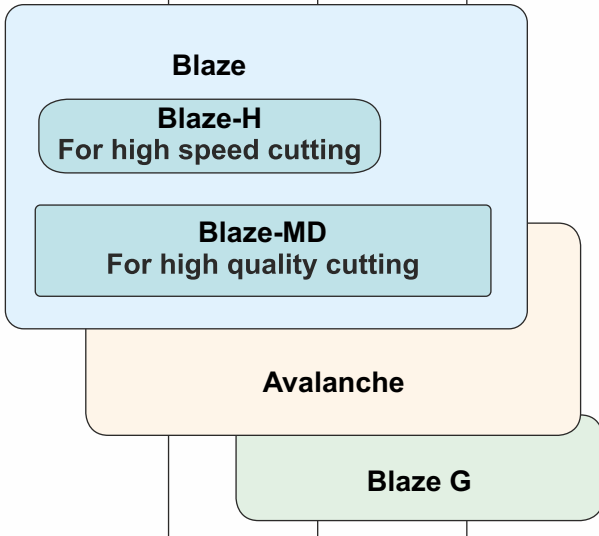
Series selection

Work material		Section steels		Nonferrous metal	General steels		
		Light gauge steels H · C · L section steels Thin pipe Steel sheet	Section steels H section steels Thick pipe	Aluminum alloys Copper alloys Carbon	Structural steels	Carbon steels	Alloy steels
Machine							
General-purpose	Section steels HK, HKA ST GT, GTA	<div style="text-align: center;"> <div style="border: 1px solid black; border-radius: 15px; padding: 10px; display: inline-block; margin-bottom: 20px;"> Rapture-K For Section steels </div> <div style="display: flex; align-items: center; justify-content: center;"> <div style="border: 1px solid black; padding: 10px; margin-right: 20px;"> Rapture </div> <div style="border: 1px solid black; border-radius: 15px; padding: 10px; display: inline-block;"> Rapture-H For high speed cutting </div> </div> </div>					
	Solids H, HA HFA HBA, PBA TC, TB S GA SGA						
		<div style="display: flex; align-items: center; justify-content: center;"> <div style="border-left: 1px solid black; border-right: 1px solid black; border-bottom: 1px solid black; width: 50px; height: 100px; margin-right: 10px;"></div> <div style="text-align: center;"> <p>High speed & Long life</p> </div> </div>					
CNC CNC machine	Solids HFA300CNC HFA400CNC HFA500CNC SGA410CNC SGA8010CNC SGA8513CNC	<div style="border: 1px solid black; border-radius: 15px; padding: 10px; display: inline-block;"> Rapture CNC </div>					









Difficult machining steels

Alloy tool steels Pre-hardened steels	Mold steels High speed steels Stainless steels	HRC43 Hardened steels	Heat resistant alloys



Blaze CNC

Description of Mark	Explanation	
		TICN multi layer Coat
	High Grade Powder HSS	 Bi-Metal Construction
	High Alloy HSS	 Variable teeth pitch
	Cobalt HSS	

Stocking marks

● : Stocked items

△ : Manufactured upon request

No mark : Not manufactured

Selection Chart

Type	Features	Product Name	Tooth Material	Wear Resistant	Chipping Resistant	
For cut off Machine	For Non Special Steels and Other Metals	Rapture	Rapture	4	5	
	For Non Special Steels and Other Metals on CNC Machine compatible	Rapture CNC4		4	4	
	For Non Special Steels and Other Metals High Speed Cutting	Rapture-H		4	4	
	For Sections and Pipes. Low Noise and Vibration	Rapture-K ¹		4	7	
	General purpose for difficult-to-cut materials	Blaze	Blaze	5	3	
	For hard steels - CNC compatible	Blaze CNC		5	3	
	For high speed cutting for Mould and Die steels	Blaze - H		5	4	
	For Accurate Cutting of Die and Mould steels	Blaze-MD		6	3	
	High hardness difficult to cut material	Avalanche	Avalanche	5	4	
	For best tool life in case of hard and tough steels	G-Avalanche		8	2	
For best tool life in case of hard and tough steels	Blaze G	Blaze	8	2		

Blade Material

FAX: High performance high alloy high speed SW: High alloy high speed

PM: High performance cobalt high HSSCo: Cobalt High

Selection Teeth

● Solids

Size of Material	Pitch																	
			(1.25)		(2)		(3)		(4)		6		8		10	12	14	18
mm	0.75/1	1/1.5	½	1.5/2		2/3		3/4		4/6	5/7	6/10		8/12				
~4																		
~10																		
~20																		
~40																		
~60																		
~100																		
~150																		
~200																		
~300																		
~400																		
~600																		
~800																		
800~																		

Application Machines	For Cut. Off Machine															
	For Rotary Machine										For Contour Machine					

In case of Bundle Cutting of round bars, please select one TPI lower than applicable for bundle length.

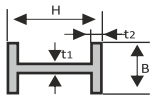
◎ : Excellent ○ : Good × : Not Used (No mark) : Not recommended

Structurals, Tubing		Solids							
SS, SM, SN Light gauge steels H-C-L section steels Thin pipe Steel sheet	SS, SM, SN Section steels H section steels Thick pipe	SS, SC, SM Structural steels	SC Carbon steels	Scr, SCM Alloy steels	SKS, NAK Alloy tool steels Pre-hardened steels	Mould steels High speed steels Stainless steels	Heat resistant alloys	Aluminum alloys Copper alloys Carbon	
○	○ ¹	◎	◎	◎	◎	○		○	
×	×	◎	◎	◎	◎	○	○	○	
×	×	◎	◎	◎	◎	○		○	
◎	◎	○	○			×	×		
×	×	○	◎	◎	◎	◎	○	○	
×	×	○	◎	◎	◎	◎	○	○	
×	×	○	◎	◎	◎	○	○	○	
×	×		○	○	◎	◎	◎		
×	×		○	○	◎	◎	○		
×	×		○	○	◎	◎	◎		
×	×		○	○	◎	◎	◎		

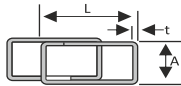
Note 1) In case of large selfstressing materials, band saw may be jammed by its stress.
We recommend "WT type band saw blade" to avoid this jamming.

● **Structural steels and tubes**

● **H section steels** _____



● **Light gauge steels** _____



● **Tube** _____



Size of Material				TPI
H	B	t ₁	t ₂	
300	150	6	9	5/7
400	200	8	13	3/4
500	200	10	16	3/4
600	200	11	17	3/4
700	300	13	24	3/4
800	300	14	26	2/3,3/4
900	300	16	28	2/3

Size of Material			TPI
L	A	T	
60	30	1.6	14
75	45	1.6	12
100	50	2.0	8/12
125	50	3.2	8/12
150	65	3.2	6/10
200	75	4.0	6/10
250	75	4.5	5/7

t \ D	TPI						
	20	40	60	80	120	160	200
2	14	14	14	14	14	14	14
4	14	14	12	12	8/12	8/12	6/10
6		8/12	8/12	6/10	6/10	5/7	5/7
8			6/10	6/10	5/7	5/7	4/6
10				5/7	5/7	4/6	4/6
12					4/6	4/6	4/6

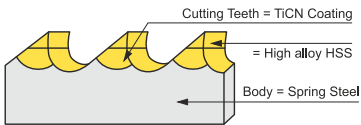
In case of cutting sections, please select a TPI such that any time at least two teeth are engaged in the section.

Blaze G



Features

- High Alloy HSS with TiCN Coating gives longer tool life.
- Excellent anti-adhesion.
- Excellent chip flow.



Work Materials

- (32HRC) Tempered steels (to 32HRC)
- Mold steels
- HSS
- Stainless steels
- High-temperature steels

Performance

Band saw	Number of cuts (pieces)		
	10	20	40
Blaze G	Work material: SUJ 2 cast material Φ 160 Saw blade: 4670 × 41 × 1, 3 × 2 山 Cutting speed: 35 m / min Cutting rate: 17 cm 2 / min		
Other company's product M42			
Blaze G	Work material: SKD 61 Φ 300 Saw blade: 5300 × 41 × 1, 3 × 2 山 Cutting speed: 30 m / min Cutting rate: 21 cm 2 / min		
Our products PM			
Other company's product M42	Work material: SUS 304 Φ 320 Saw blade: 4570 × 34 × 1, 0 7 × 2 山 Cutting speed: 30 m / min Cutting rate: 13 cm 2 / min		
Blaze G			
Other company's product M42			

Blaze CNC Rapture CNC



Features

- Longer fatigue life by body material of spring steels.
- Faster cutting by positive rake and wide gullets.
- Smooth finish and straight cut.

Work Materials

- Structural steels
- Alloy steels
- Stainless steels
- High-temperature steels
- Tool steels

Applicable Machines

HFA-300CNC、400CNC、500CNC
SGA410CNC、SGA8010CNC、SGA8513CNC

Performance

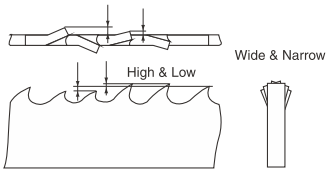
Band saw	(TPI)	Lifespan × 10 ⁴ (cm ²)	
		5	10
Blaze CNC Conventional product	3/4H	Workpiece: SUS Casting Φ 160	
	3/4		
Blaze CNC Conventional product	2/3H	Workpiece material: S45C Φ 280	
	2/3		
Blaze CNC Conventional product	2/3H	Work material: SKD 61 Φ 300	
	2/3		

Blaze MD



Features

- Long tool life by high alloy HSS.
- Smooth finish and straight cut.



Rapture K

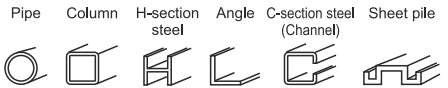


Features

- Suitable for profiles and bundles.
- Excellent chipping resistance and low vibration in VL pitch pattern.
- Longer life by tooth made from Super HSS.

Work Materials

- Structure materials



Blaze

- It is suitable for Stainless steels



Blaze CNC

- Applicable for CNC machine by adoption of tough spring steels as the body material. For difficult to cut steels.



How to order

Type Full length Width Number of Teeth

Stocking marks

● : Stocked items

△ : Manufactured upon request

No mark : Not manufactured

Width	Thickness	Stock						
		TPI						
		0.75/1	1/1.5	1/2	1.5/2	2/3	3/4	4/6
27	0.95						△	△
34	1.07					△	△	
41	1.3					△	△	
54	1.6		△	△	△			
67	1.6	△	△	△	△			

Metal Band Saw Blades for Cut Off Machine

Rapture

- Applicable from solid material to variant material.



How to order

Type Full length Width Number of Teeth

(Unit) : mm

Width	Thickness	Stock								
		TPI								
		0.75/1	1/1.5	1/2	1.5/2	2/3	3/4	4/6	5/7	6/10
27	0.95					△		△	△	△
27	1.07						△	△		
34	1.07					△	△	△		
41	1.3					△	△	△		
41	1.5				△					
54	1.6		△	△	△	△	△			
67	1.6		△	△	△	△				
80	1.6	△								

How to order

Type Full length Width Number of Teeth

(Unit) : mm

Width	Thickness	Stock			
		TPI			
		2	3	4	6
27	0.95		△	△	△
34	1.07	△	△	△	
41	1.3	△	△		

Stocking marks

● : Stocked items

△ : Manufactured upon request

No mark : Not manufactured

Metal Band Saw Blades for Cut Off Machine

Rapture WT

- WT Type Bandsaw blade



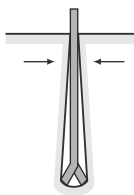
How to order

Type Full length Width Number of Teeth

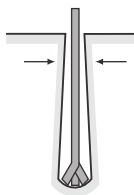


(Unit) : mm

Width	Thickness	Stock	
		TPI	
		2/3	3/4
41	1.3	△	△
54	1.6	△	△
67	1.6	△	△



Standard



WT Type

- WT Type Bandsaw blade

In case of large self-stressing materials, band saw may be jammed by its stress. We recommend "WT type band saw blade" to avoid this jamming.

Rapture K

- This band saw blade having variable teeth pitch and strong teeth form is suitable for cutting of profiles and bundles.



How to order

Type Full length Width Number of Teeth



(Unit) : mm

Width	Thickness	Stock		
		TPI		
		2/3K	3/4K	4/6K
27	0.95		△	△
34	1.07		△	△
41	1.3		△	
54	1.6	△	△	
67	1.6	△	△	

Stocking marks

● : Stocked items

△ : Manufactured upon request

No mark : Not manufactured



Metal Band Saw Blades for Cut Off Machine

Blaze H

- Applicable for high speed cutting by its sharp tooth design.



How to order

Type Full length Width Number of Teeth



Please specify thickness only for width 54

Width	Thickness	Stock TPI	
		2/3H	3/4H
		27	0.95
34	1.07	△	△
41	1.3	△	△
54	1.3	△	
54	1.6	△	
67	1.6	△	

Avalanche

- It is suitable for efficient cutting of hard to cut structural and tubing.



How to order

Type Full length Width Number of Teeth



(Unit) : mm

Width	Thickness	Stock TPI						
		0.75/1	1/1.5	1.5/2	2/3	3/4	4/6	5/7
		27	0.95				●	●
34	1.07				●	●	●	△
41	1.3			●	●	●	△	
54	1.6			●	●	●		
67	1.6	●	●	●	●	△		

Blaze MD

- Possible on a smooth cutting surface, and a small cutting resistance.



How to order

Type Full length Width Number of Teeth



(Unit) : mm



Width	Thickness	Stock TPI									
		0.75/1	1/1.5	1.5/2	2/3	3/4	4/6	5/7	6/10	8/12	10/14
		19	0.95						●	●	●
27	0.95				●	●	●	●	●	●	●
34	1.07				●	●	●	●	●		
41	1.3			●	●	●	●	●	●		
54	1.6			●	●	●	●	●			
67	1.6	●	●	●	●	●	●				

Avalanche G

- Applicable for difficult to machine materials, structures, tubes etc. For longer tool life in hardened steels



How to order

Type Full length Width Number of Teeth



(Unit) : mm

Width	Thickness	Stock						
		TPI						
		075/1	1/1.5	1.5/2	2/3	3/4	4/6	5/7
27	0.95				●	●	●	△
34	1.07				●	●	△	△
41	1.3				●	●	△	△
54	1.6							
67	1.6							

Blaze G

- Applicable for difficult to machine materials, structures, tubes etc.. For longer tool life in hardened steels.



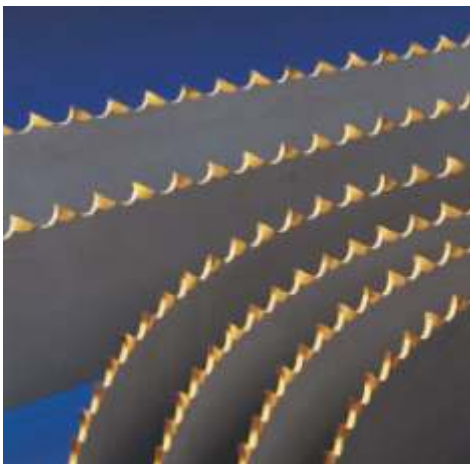
How to order

Type Full length Width Number of Teeth



(Unit) : mm

Width	Thickness	Stock	
		TPI	
		2/3	3/4
27	0.95		△
34	1.07	△	△
41	1.3	△	△
54	1.6	△	
67	1.6	△	



Stocking marks

- : Stocked items

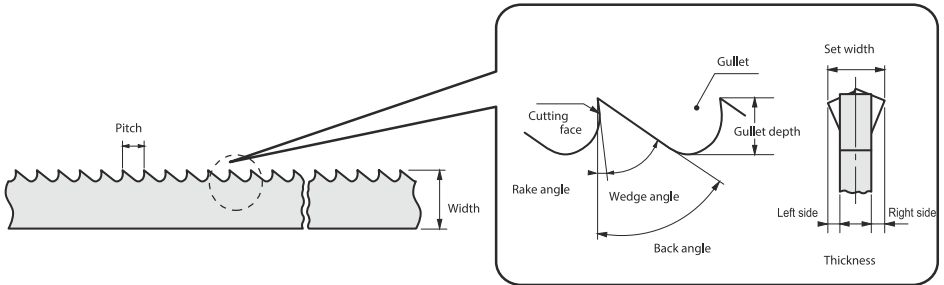
△ : Manufactured upon request

No mark : Not manufactured

Packing quantity of metal band saw for cut-off machine Packed Quantity

Technical Reference

Nomenclature



Tooth form

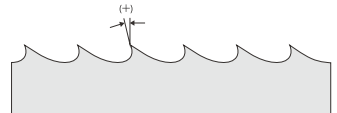
Regular tooth form

Regular tooth with rake angle of 0° is suitable for cutting short-chipping materials and high-carbon steels, tool steels and cast irons. This tooth form can be usually used for work piece with thin-plates.



Hook tooth form

Hook tooth with positive rake angle is suitable for long-chipping, tough materials, non-ferrous metals.

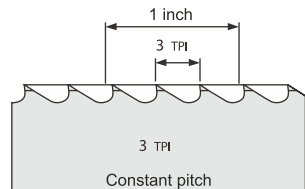


Tooth pitch

Tooth pitch is defined as the number of teeth per inch (TPI).

Constant pitch

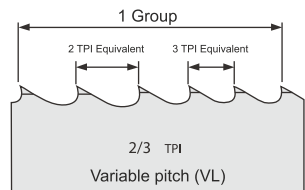
Constant pitch has uniform tooth spacing.
2•3•4



Variable pitch (VL)

Variable pitch has different tooth spacing within one tooth interval. This pitch is marked by two dimensions, example $4/6$ (TPI).

$2/3 \cdot 3/4 \cdot 4/6$



Type of tooth set

By means of the tooth set, with which the teeth alternately protrude to the left and right beyond the level of the band body, free-cutting action of the band saw blade is achieved.

Standard tooth set

Three tooth sequence- left, right, straight, used in constant pitch.



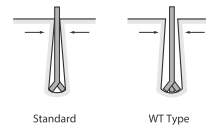
Group tooth set

Multi-tooth sequence depending on tooth pitch, used in variable pitch.



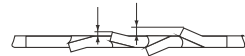
WT Type Bandsaw Blade for residual stress material

In case of large self-stressing materials, band saw may be jammed by its stress. We recommend "WT type band saw blade" to avoid this jamming.



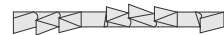
Combination tooth set

A set of teeth with different widths is used with high and low forms to reduce stress, cutting resistance and vibration.



Wave tooth set

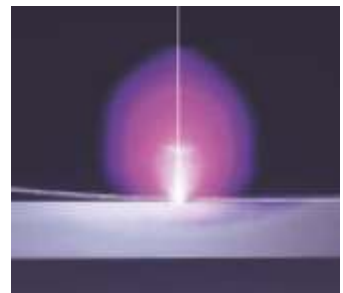
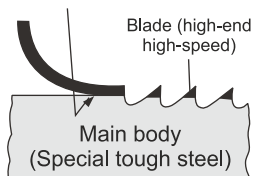
Wave tooth set is used in fine pitch tooth and suited for materials such as sheet metal, thin walled pipes and profiles.



Tooth material & Bi-Metal Construction






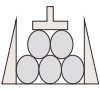





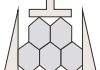











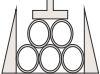
























Tooth material is made from Powder HSS or Super HSS and body material is made from spring steels. Tooth and body are welded strongly by Electron Beam Welding.

Electron Beam Welding



Various Clamping Methods based on the shape of materials and sections.

Bundle cutting in general is a complex process, resulting in chipping of teeth while cutting. The primary difficulties include moving of one element in the bundle during cutting, improper clamping and wrong selection of TPI etc. Following are the guidelines to clamp bundles.

Shape	Clamp method by bundle number				
	1 Piece	2 Piece	3 Piece	4 Piece	5 Piece
Round bar 					
Hexagonal bar 					
H-section steel 					
Pipe 					
Square pipe 					
Groove shape steel 					
Chevron steel 					
C-section steel 					
Rail 					

Recommended Cutting Parameters

Work materials		Band dimension(mm)					
		27 × 0.95	34 × 1.07	41 × 1.3	54 × 1.6	67/80 × 1.6	
		Work length (mm)					
		200	250	300	500	600	
		Condition					
Structural steels	SS *** SM *** STKM ***	Cutting speed(m/min)	70 ~ 80	60 ~ 70	50 ~ 60	45 ~ 50	40 ~ 50
		Cutting rate(cm ² /min)	50 ~ 60			50 ~ 60	
Cast-hardening steels Automatic steels	S * * C SUM ** SNCM ***	Cutting speed(m/min)	65 ~ 80	55 ~ 70	50 ~ 65	40 ~ 55	40 ~ 55
		Cutting rate(cm ² /min)	45 ~ 55			45 ~ 55	
Alloy steels	SCr *** SCM ***	Cutting speed(m/min)	55 ~ 70	50 ~ 65	45 ~ 60	40 ~ 55	40 ~ 55
		Cutting rate(cm ² /min)	40 ~ 50			40 ~ 50	
Bearing steels, Spring steels, Tool steels, Tempered steels	SUJ *** SUP *** SKS *** NAK ***	Cutting speed(m/min)	40 ~ 55	40 ~ 55	35 ~ 50	30 ~ 45	30 ~ 45
		Cutting rate(cm ² /min)	30 ~ 40			25 ~ 35	
Mold steels, High-speed steels	SKD ** SKH **	Cutting speed(m/min)	35 ~ 45	30 ~ 45	25 ~ 40	25 ~ 40	20 ~ 35
		Cutting rate(cm ² /min)	20 ~ 30			20 ~ 30	
Stainless steels, Heat-resistant steels	SUS *** SUH *** SKT ***	Cutting speed(m/min)	30 ~ 45	30 ~ 45	25 ~ 40	25 ~ 40	20 ~ 35
		Cutting rate(cm ² /min)	20 ~ 30			20 ~ 30	
Nickel based alloys	Inconel Hastelloy Waspalloy	Cutting speed(m/min)	20 ~ 27	15 ~ 20	12 ~ 18	8 ~ 15	8 ~ 15
		Cutting rate(cm ² /min)	7 ~ 20			5 ~ 15	
Aluminum alloys, Aluminum cast alloys	A * * * * AC * * ADC * *	Cutting speed(m/min)	80 ~ 150 (500 ~ 2000)	80 ~ 150 (500 ~ 2000)	80 ~ 150 (500 ~ 2000)	60 ~ 80	60 ~ 80
		Cutting rate(cm ² /min)	70 ~ 1500			70 ~ 1500	
Copper alloys	C * * * *	Cutting speed(m/min)	60 ~ 90 (100 ~ 150)	60 ~ 90 (100 ~ 150)	60 ~ 90 (100 ~ 150)	40 ~ 60	40 ~ 60
		Cutting rate(cm ² /min)	40 ~ 50			30 ~ 40	
Graphitic carbon		Cutting speed(m/min)	70 ~ 90 (200 ~ 500)	70 ~ 90 (200 ~ 500)	70 ~ 90 (200 ~ 500)	50 ~ 70	50 ~ 70
		Cutting rate(cm ² /min)	45 ~ 60			40 ~ 50	
Structural		Cutting speed(m/min)	50 ~ 80	50 ~ 80	50 ~ 80	45 ~ 65	45 ~ 65
		Cutting rate(cm ² /min)	40 ~ 70			30 ~ 50	

The cutting Parameters suggested above are general guidelines. Fine tuning these parameters according to the work material, Type of Saw Blade and Sawing machine will result in best outcome.

Trouble-Shooting

ITEM	COMPLAINT	CAUSE/ OBSERVATION	COUNTERMEASURES
Cutting Quality	Tapper Cutting	EXCESSIVE OR LOW BLADE TENSION	Maintain blade tension between 18 to 20 kgf/sq.mm.(25000 to 28000 PSI)
		WORN OUT BEARINGS OR ROLLERS	Replace bearings / rollers which twist the blade to vertical position/
		GUIDES FAR FROM JOB	Place the moveable side arm closer to the work piece/job.
		EXCESSIVE CUTTING FEED	Change the cutting feed as per recondition for the work material.
		ABNORMAL WEAR ON BLADE	Change the cutting speed as per the recommendation for work material in the next blade. Remember to conduct breaking in of the teeth.
		BAD SURFACE OF CARBIDE GUIDES	Check the three carbide guides and replace them if there is excessive wear.
		JAWS HOLDING JOB ARE LOOSE	Check the jaw pressure and straightness with respect to the job and ensure firm positioning of work under the blade.
	Bad Surface Finish	LARGE TPI	Use suitable TPI as per recommendation for the shape and dimensions of job.
		EXCESSIVE CUTTING FEED	Use recommended cutting feed as per the work material. Optimisation of feed may be required to achieve desired surface finish.
		ABNORMAL WEAR ON BLADE	Improving cutting conditions and choosing the right grade and tooth profile of blade will reduce the wear and improve tool life.
Blade Damage	BLADE BREAKAGE	VIBRATIONS OF MACHINE OR BOW ARM	Machine may need over hauling. A stable and sturdy machine gives best blade performance.
		EXCESSIVE CUTTING FEED	Use recommended cutting feed as per the work material.
		EXCESSIVE BLADE TENSION	Maintain blade tension between 18 to 20 kgf/sq.mm.(25000 to 28000 PSI)
		LOOSE CARBIDE GUIDES	Check the carbide guides and place them close to the blade but not tight. Guides can not restrict the movement of blade.
		LOOSE JAWS HOLDING THE JOB	Jaws clamping the work piece must be firm and must hold the job in place tight.
		CRACKING THE BACK OF BLADE	Check the carbide TOP guide and replace if required. The carbide guide must not have a groove. Periodic replacement of top guide will help better blade life.
		CRACKING FROM THE GULLET OF BLADE	Smaller TPI and higher feed will result in cracking of blade from gullets.
		BLADE SHEARING/SCRACHES ALONG THE LENGTH	Bearings and Rollers guiding the blade before guide arms may be adjusted to avoid shearing of blade. A straight mark along ghte length of the blade shows fatigue resulting out of bearings and rollers.
		BLADE WEARING/SCRACHES ALONG THE LENGTH	Loosen the Carbide SIDE guides to ensure blade position on the job to be vertical. Replace them if required.
		BLADE RUBBING ON THE COLAR OF THE WHEEL	Machine blade wheels need alignment. A well aligned set of wheels will give best tool life.
	CHIP BRUSH NOT WORKING OR ABSENT	A functional chip brush ensures clean blade entering the job every time. Its absense will result in inconsistent tool life.Machines with Motorised chipbrushes give best tool life and clean cuts.	
	Blade Teeth Ripping Off	EXCESSIVE CUTTING FEED	Excessive blade feed results in high impact load on the teeth and hence teeth break. One broken tooth initiates series of teeth breakages. Use Appropriate and recommended feed.
		CHIP BRUSH NOT WORKING OR ABSENT	A tooth with a gullet filled with a chip, when enters the job, results in cracking of the blade from that gullet. Change the chip brush and ensure it is working.
		CUTTING OIL ABSENT	Maintain 5% cutting oil concentration for Band Saw Machines.
		TPI TOO BIG OR FEED TOO HIGH	Use suitable TPI as per recommendation for the shape, dimensions and Bundle size of job.
HYDRAULIC FEED UNEVEN		Check the hydraulic cylinder and change the oil seals if required. any leakage in the hydraulic system will result in uneven feed of blade and jerks.	
TWISTING OF JOB DURING CUTTING		This happens during bundle cutting when the jobs are not straight or Top Clamp of the Jaw is absent or loose. Take care not to have larger bundles or use straight jobs with firm top clamp near the jaws.	
VIBRATION OF THE MACHINE		Grout the machine well, over haul the machine time to time, avoid blades with constant pitch, tighten the jaws holding the job, check mounting of motor and gear box.	
Others	Vibration and Noise	EXCESSIVE CUTTING SPEED	Reduce the blade speed till noise subsides.
		EXCESSIVE BLADE WEAR	Use better grade of blade or use Wide Teeth blades if job is soft,
		TPI TOO SMALL	Use recommended TPI or change to VL type.

Customer Notes

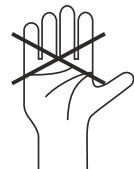
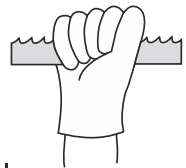
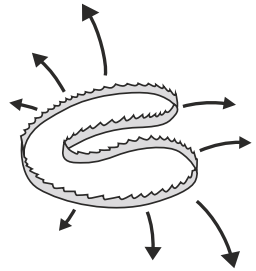
Attention on safety



Warning

Read this “Attention on safety”

- A bandsaw blades is dangerous. Be fully careful because it has danger when a saw edge is untied and spread.
- Use leather gloves in the installation and the removal of the bandsaw blades.
- Be sure to cut the main power supply of the machine when you replace a bandsaw blade.
- Fix work materials firmly.
- Never touch a bandsaw blades during the rotation.
- Read the instruction manual of the machine, and use it properly.
- Recommend running-in a bandsaw blade to achieve the full life.
- Use the cutting fluids fully which is suitable for work material.
- Be fully careful of the disposal of the bandaw blades which has been used.





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Dealer's Name



Revolution In Sawing Technology

NURA Introduces a New Series of Bandsaw Blade *Avalanche*



Avalanche



Special Feature :-

NEW TOOTH MATERIAL AND DESIGN
 BEST SUITABLE FOR HARD TO CUT MATERIAL
 FASTER CUTTING IN GENERAL METAL CUTTING
 INCREASED TOOL LIFE CONTRIBUTING LOWER CPC

Availability

Avalanche

Width	Thickness	Stock						
		TPI						
		0.75/1	1/1.5	1.5/2	2/3	3/4	4/6	5/7
27	0.95				●	●	●	●
34	1.07				●	●	●	△
41	1.3			●	●	●	△	
54	1.6			●	●	●		
67	1.6	●	●	●	●	△		

Avalanche G

Width	Thickness	Stock						
		TPI						
		0.75/1	1/1.5	1.5/2	2/3	3/4	4/6	5/7
27	0.95				●	●	●	△
34	1.07				●	●	△	△
41	1.3				●	●	△	△
54	1.6							
67	1.6							

Stocking Marks

- Stocked Items
- △ Manufactured upon request